

Date: Wednesday, 18/06/2008 1:26:57 PM  
User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : COVER  
Job Number : 39925  
Estimate Number : 10287  
P.O. Number :  
This Issue : 18/06/2008 S.O. No. :  
Prsht Rev. : NC Part Number : D32021  
First Issue : // Type : SMALL / MED FAB Drawing Number : D3202 REVC PRELIM Rev. 15  
Previous Run : 38445 Drawing Revision : C PRELIM 16  
Written By : Due Date : 30/06/2008 Qty: 30 Um: Each  
Checked & Approved By : JLD 08.6.18  
Comment : Est Rev:B No Longer Made In House 05-11-06 JLM  
Est Rev:C Now on Waterjet 07-04-18 JLM  
Est Rev:D chg to revC as per dwg 08-04-21 DD  
verified by:JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S032 5052-H32 .032 Sheet



OUT OF MATERIAL



Comment: Qty.: 1.6286 sf(s)/Unit Total : 48.8565 sf(s)

5052-H32 .032 Sheet

Batch: 108462 HB 8-7-16

~~HB 8-7-16~~

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3202

Dwg Rev: C HB 8-7-16

Prog Rev: C

(B)

2-Deburr if necessary HB 8-7-16

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 8-7-16



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S.00017 (+13)

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

217/m/58/07H17

(130)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: COVER

Job Number: 39925

Part Number: D32021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M106442



13x

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:40  
320 °F  
12:10

M-L 08/07/21

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



13

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/07/21

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

8/9/22 (13)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/22

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-22

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

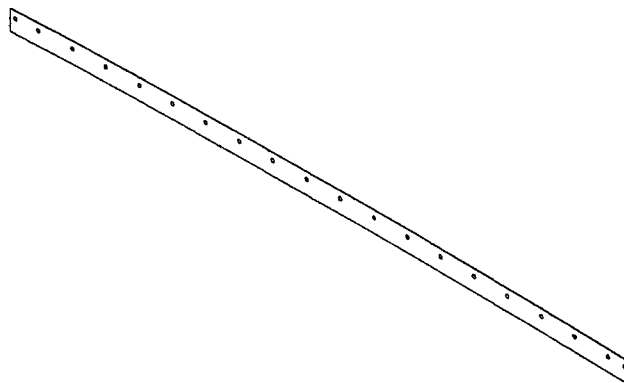
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

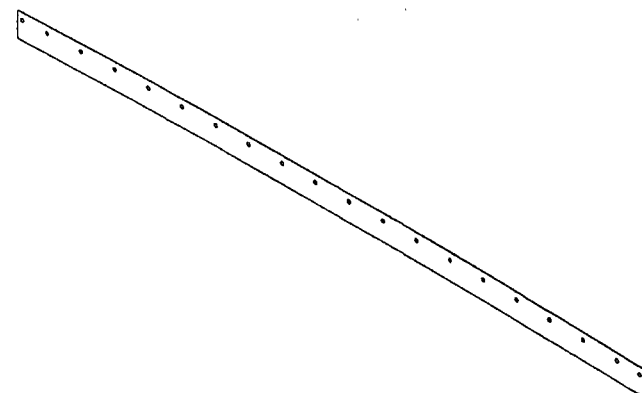
**NOTE:** Date & initial all entries



52665  
Jm



**D3202-1 COVER**



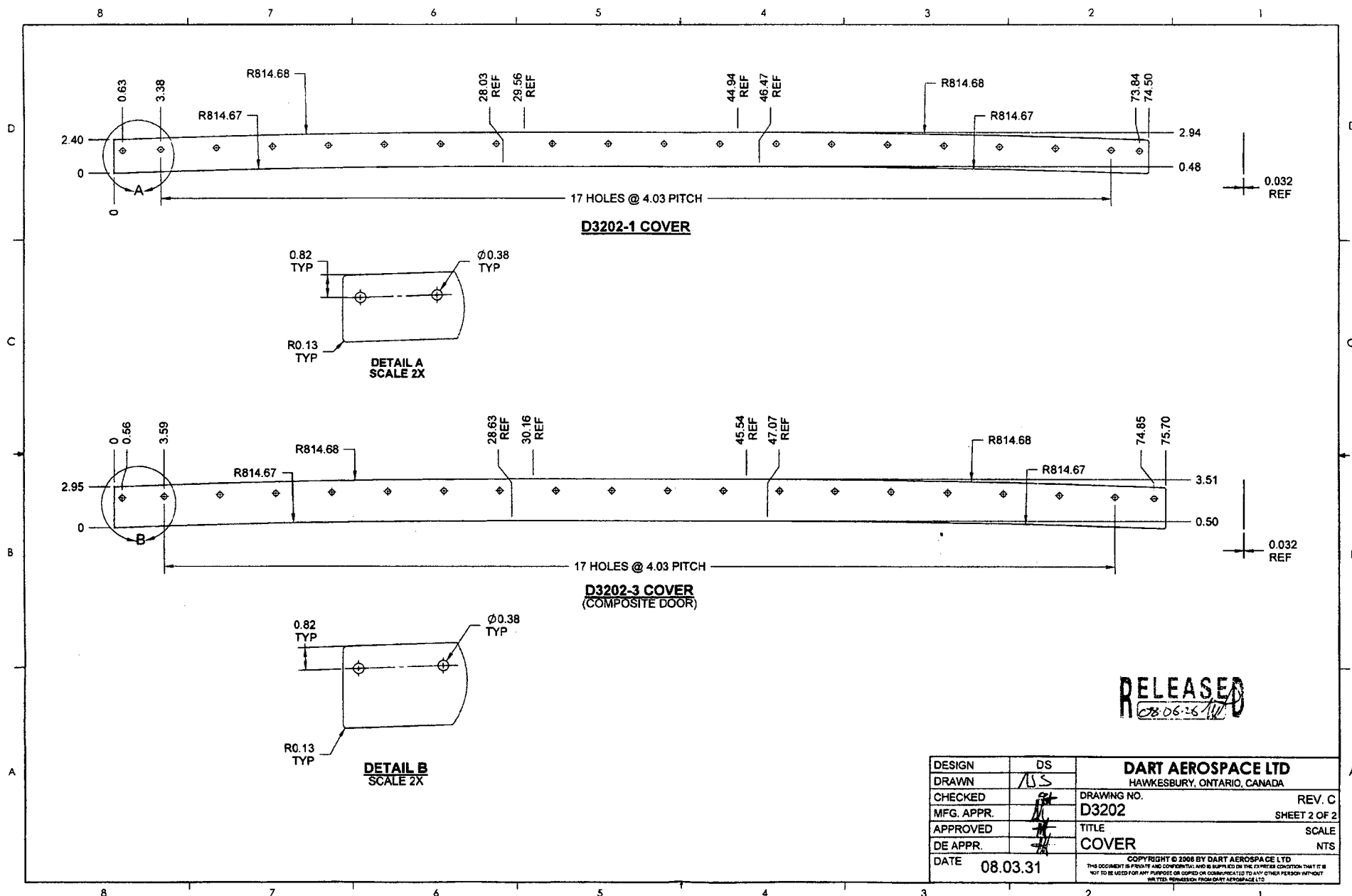
**D3202-3 COVER  
(COMPOSITE DOOR)**

**RELEASED**  
08.03.14

**NOTES:**

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.032 THICK  
PER AMS-QQ-A-250/8 OR AMS 4016  
REF. DART SPEC M5052H32S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3202-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.56 lbs APPROX FOR -1  
: 0.61 lbs APPROX FOR -3

C	ADD -3 FOR COMPOSITE DOOR. REFORMAT ENTIRE DRAWING TO SOLIDWORKS STANDARD. INCORPORATE CHANGE B1 (CLARIFY MID-SPAN DIMENSION)	AJS	08.03.31
B	RE-DESIGN PART NOW CURVED	CP	03.10.16
A	NEW ISSUE	CP	01.01.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3202	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	COVER	NTS
DATE	08.03.31	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



RELEASED  
08-06-26

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	MS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SL	DRAWING NO. <b>D3202</b>	REV. C
MFG. APPR.	SL	SHEET 2 OF 2	
APPROVED	SL	TITLE <b>COVER</b>	SCALE NTS
DE APPR.	SL	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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